User:

Wednesday, 11/06/2008 11:03:00 AM

Julie Lecocq

### **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

**Drawing Name** 

: LUG BRACKET

Job Number **Estimate Number** 

: 39819 : 10009

P.O. Number

: 11/06/2008

Part Number S.O. No. :

: D27351

This Issue Prsht Rev. First Issue

: NC

: // : 38455

: SMALL /MED FAB Type

**Drawing Number** 

: D2735 REV C

**Project Number** 

: N/A

**Drawing Revision** 

: C

Material **Due Date** 

: 23/06/2008

Each

Written By

Previous Run

Checked & Approved By

40 Um:

Comment

est rev D

Removed from 9 Digit wateriet

05-10-25 06.09.19

JLM FC

**Additional Product** 



Job Number:



, Seq. #:

**Machine Or Operation:** 

Description:

1.0

M1010S125

1010-1025 sheet .125

Comment: Qty.:

0.1733 sf(s)/Unit

Total:

1010-1025 sheet .125

batch: 10833

6.9300 sf(s)

2.0

WATER JET





Comment: FLOW WATER JET

1-Cut as per Dwg D2735 (D2735-1)

Dwg Rev: C

Prog Rev: \_ C

B 8-7-3

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK .





(ounles

Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204

2-Deburr if required.



S6 00/18/08/

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
			1								
	·			1/2							
				11							

Part No:	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	Approval Chief Eng				
DATE	STEP	Section A	Initial Chief Eng	Action Description Sign & Date	Section C		Approval QC Inspector			
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Wednesday, 11/06/2008 11:03:00 AM Date: User: Julie Lecocq **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: LUG BRACKET** Job Number: 39819 Part Number: D27351 Job Number: Seq. #: **Machine Or Operation:** Description: 6.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 7.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: id/ 8.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE MF 08-12-08 Job Completion

W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE By				Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No		DAD #1 Fault Category	NCD: Voi	No DO	A -	Deter					

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: _	
			QA: N/C C	losed:	Date:	

NCR:		, ·	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	**	Verification	Annacial	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng				
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DART AEROSPACE LTD	Work Order:	39819
Description: Lug Bracket	Part Number:	D2735-1
Inspection Dwg: D2735 Rev: C		Page 1 of 1

·	FIRST	ARTICLE IN	ISPECTIO	ON CHE	CKLIST		
	X	First Artic	cle	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	mments
0.41	+/-0.030	,402	X				
6.594	+/-0.010	6.598	×				
R0.63	+/-0.030	.63	*				
1.750	+/-0.010	1,746	×				
Ø0.438	+0.006/-0.001	,438	*				
0.75	+/-0.030	.744	*		-		
R1.00	+/-0.030	(.00	æ				
1.50	+/-0.030	1.514	×				
0.125	+/-0.010	.115	×				
				·			
Measured by: Date:	8-7-3	Audited by: Date:	०८।जी	04	Prototype Ap	Date:	N/A N/A
Rev Date A 07.02.02	Change New Issue					evised by	Approved

	WORK ORDER CHANGES											
STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector						
		STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr						

Part No:	PAR #:	Fault Category:	_ NCR: Yes No	DQA:	Date:
		•	QA: N/C	Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B				Approval			
DATE	STEP	STEP	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
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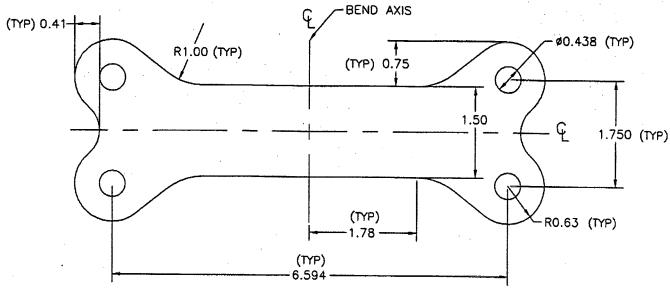




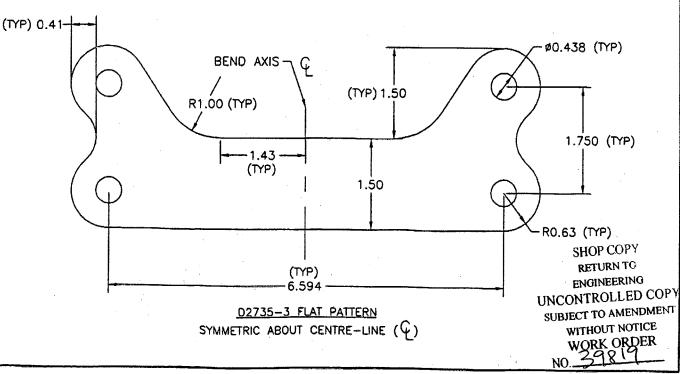
0ESIGN		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHEC	P	APPROVED KE	D2735 REV. SHEET 1 OF	-
DATE			TITLE SCAL	F.
98.1	12.14		LUG BRACKET	:3
Α		97.12.14	NEW ISSUE	_
В		98.10.23	UPDATE MATERIAL (TSR A1114)	

# RELEASED

С REMOVE TOOLING HOLES (TSR A1040) 98.12.14



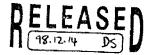
#### D2735-1 FLAT PATTERN SYMMETRIC ABOUT BOTH CENTRE-LINES (G)

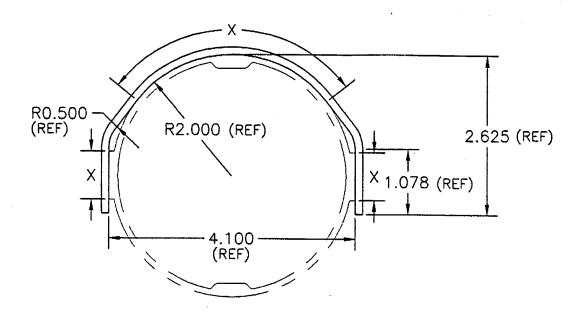


W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				·.						
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQA</b> :	Date: _			
					QA: N	C Closed:	Date: _			
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR	)				
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval		
	J GILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector		
						100				



DESIGN	DRAWN BY	DART AEROS HAWKESBURY, ON	
CHECKED	APPROVED KE	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE		TITLE	SCALE
98.12.14		LUG BRACKET	2:3





D2735-1 AND D2735-3 BEND DETAIL
D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL

0.125 THICK (11 GAUGE)

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED RETURN TO ENGINEERING

ALL DIMENSIONS ARE IN INCHES

HINCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 39 813

W/O:		WORK ORDER CHANGES			211		
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
ч.			QA: N/C	Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B			A		
DATE	STEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC inspector	
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